

5/20

244.3

DART AEROSPACE LTD	Work Order:	23020
Description: Sliding Plate	Part Number:	D3333-3
Dwg: D3333 Rev. ^B X PAGE 2	Qty:	24
05.04.12		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.04.13	24
2	MV	Cut blanks: 4.000" x 0.500" thick x 9.620" long Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel (M1010-B4.000x00.500) Identify for D3333-3 Batch: <u>M16634</u>	EP	05/05/05	24
3	MV	Machine as per Folio FA483 and Dwg D3333 Identify as D3333-3	EP	05/05/05	24
4	QC2	Inspect parts as they come off the CNC machine	EP	05/05/05	24
5	QC8	Second check	ml	05/05/06	24
6	MV	Deburr and Grind 45° chamfer on opposite side of pocket along edges as per Dwg D3333	BL	05/05/10	24
7	QC5	Inspect work to Step 6	EP	05/05/10	24
8	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Ensure to mask threaded holes and sides	ml	05/05/19	24
9	QC3	Inspect Powder Coat	ml	05/05/30	20
10	ST	Identify and Stock	ml	05/05/30	20
11	AC	Cost / part: <u>17.62</u>	Suc	05.06.01	20
12	DC	Close W/O <u>17.83</u> Inspect Level 21	HJ	05.06.03	20

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED
05-01-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

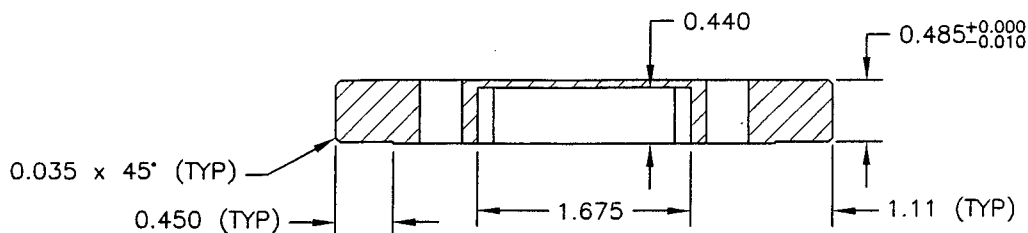
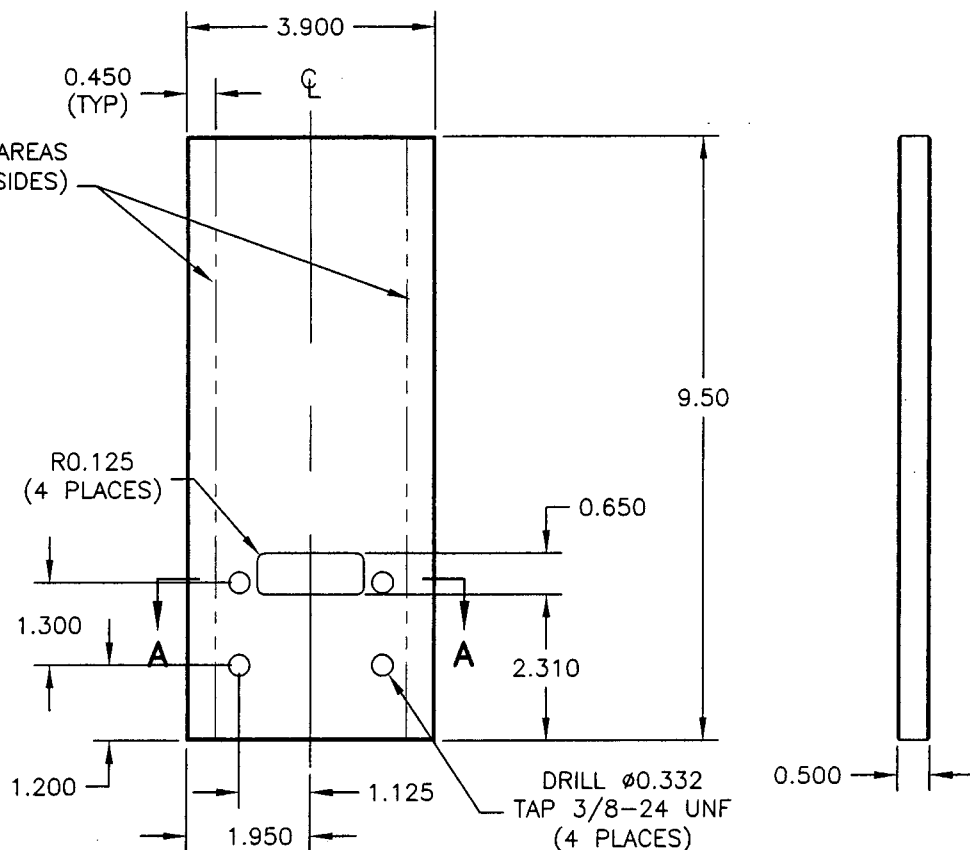
QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3333	REV. B SHEET 2 OF 3
DATE 05.02.18	TITLE PLATE		SCALE 1:4

RELEASED
05/02/22

DO NOT PAINT THESE AREAS
(TYPICAL ON BOTH SIDES)



SECTION A-A

D3333-3 SLIDING PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY

TO BE USED FOR

UNIT COPY

FOR ASSEMBLY

WITHOUT NOTICE

WORK ORDER

NO. 23020

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2005
02:25 pm

Work Order No : 0023020
Project Name : D3333-3
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : D3333-3
Description : Sliding Plate
Manufactured : Yes
Amount Req'd : 24
Amount Done : 0
Start Date : 04-12-05
Est Finish Date : 05-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 23020
Description: Sliding Plate		Part Number: D3333-3
Inspection Dwg: D3333	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.450	± 0.010	0.443	✓			
3.900	± 0.010	3.903	✓			
9.50	± 0.036	9.504	✓			
0.650	± 0.010	0.648	✓			
2.310	± 0.010	2.312	✓			
$\phi 0.332$	$\begin{matrix} +0.005 \\ -0.000 \end{matrix}$	0.333	✓			
1.950	± 0.010	1.952	✓			
1.200	± 0.010	1.195	✓			
1.300	± 0.010	1.296	✓			
0.500	± 0.010	0.495	✓			Mat. Thickness
0.440	± 0.010	0.442	✓			
0.485	$\begin{matrix} +0.000 \\ -0.010 \end{matrix}$	0.485	✓			
1.11	± 0.030	1.115	✓			
1.675	± 0.010	1.674	✓			
0.450	± 0.010		✓			
0.035x45°	± 0.010	0.035x45°	✓			

Measured by: <i>EP</i>	Audited by: <i>TSC</i>	Prototype Approval: <i>N/A</i>
Date: 05/05/05	Date: 05/05/05	Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	